

Work Order ID 73991

Page 1

Tuesday, September 20, 2011 10:26:33 AM

Item ID: D206-642-241

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 9/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *mk*Date: *11-09-20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-642-241

CHG005

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
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Run Hours

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Plan
CodeAccept
QtyReject
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NumberInsp.
Stamp

110

0.00



Skidtubes

0.00

Skidtubes

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

> DP 12-2-23

SAD 12-02-25

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Page 3

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QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

SAD 12-02-25

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

5 12/02/27

W/O:		WORK ORDER CHANGES					
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Page 4

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Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open crossbolt holes to Ø0.3125"

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650.
Open Aft cap hole #6.

3-Deburr tube and blow out chips from inside the tube

1 SAD 12-02-28

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

12-02-27

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

DP 12-2-28

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail
(without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

DC 12/62/28

170

0.00



QC

Memo

0.00

Quality Control

QC6- Inspect dimensions to drawing

DP

12-2-28

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Page 6

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Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 12/02/28 Time: 3:25

Finish Date: 12/02/29 Time: 1:30

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Sikaflex-291 ☐ 119 999 ☐

Sikaflex expire date: 12/08/13

DC 12/02/28

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1. 0 BER 12/02/29

W/O:		WORK ORDER CHANGES					
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Page 7

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☒ M 120164

3-Grind welds flush as per Dwg D2650.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☒ NONE

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

} BE 12/02/29

B 12/03/04

3E 12/02/29

DP 12-3-5

W/O:		WORK ORDER CHANGES					
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Page 8

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	HandFinishing	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							
	Install D2680-041 Nut Plate as per Dwg D2650								
215	QC9								
220	QC10- Inspect visual per QSI004- ground welds	0.00							
	QC								
Quality Control	Memo	0.00							
230	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

1 BB 12/03/04

AA 12.03.06

S 12/03/06

S 12/03/06

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 9

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1X J m / 12/03/06

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:40
3200F
12:10

1X J m / 12/03/07

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 d ll 12/03/07

W/O:		WORK ORDER CHANGES					
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Page 10

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☒ 11/11/09 ☐

Sikaflex expire date: ☐ 12/09

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

4 -Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R ☐ Sikaflex-291 ☒ 11/11/09 ☐

Sikaflex expire date: ☐ 12/09

5 -Wing Walk as per Dwg D2650-3 and QSI 005 4.4

A/R Batch: 11/12/09

Batch: 11/12/09

1 6 11/12/09

300



QC

Quality Control

QCS- Inspect part completeness to step on W/O

0.00

Memo

0.00

5 12/09

10

W/O:		WORK ORDER CHANGES					
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Page 11

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Stop

Sequence ID/
Work Center IDOperation
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Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

310

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-664-241

Location:

PPP Rev: PPP 81226

320

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

6/14/3/1 86

12/3/22

MF

(2-03-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

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Required Date: 10/11/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev: 04.12.02 Revised procedural steps KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:EC IPP rev Q 10.02.19 per PAR 09-043 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620  Skidtube, 206 Skidtube		Manufactured	No			110	Each	52.0000	1	1		SAD 12-02-24	
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Location Loc Qty Loc Code

LG	52	
68136	1	3P645
71616	5	
71617	6	
73781	10	
73786	10	
73787	10	
73788	10	

D3286-1  Doubler		Manufactured	No			110	Each	32.0000	2	2		SAD 12-02-25	
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--------------	--

Location Loc Qty Loc Code

LG002	32	
52844	11	
64563	21	B78014

D2647  Cap		Manufactured	No			110	Each	44.0000	1	1		SAD BE 12-02-24	
--	--	--------------	----	--	--	-----	------	---------	---	---	--	-----------------	--

Location Loc Qty Loc Code

LG002	44	
55352	14	
71171	30	B75482

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Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-3

Manufactured No

180

Each

4.0000

1

1



Web

B73442



1

DC 12/02/28

Location

Loc Qty

Loc Code

LG

4

64876

4

CR3212-4-04

Purchased No

180

Each

1,655.000

52

52



Cherry Rivet

Location 119075

Loc Qty

Loc Code

ST311

1655

116471

78

117816

477

118686

100

118840

1000

D2649

Manufactured No

200

Each

289.0000

18

18



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

6

68224

2

71355

2

72704

2

LG001

283

65317

1

68507

11

73390

271



3E12/02/29

B79504 *18

Tuesday, September 20, 2011 10:26:30 AM

Shop Packet Print

Page 2

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Page 3

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Start Qty: 1.00

Required Qty: 1.00

D3286-3
Spacer
Manufactured No 200 Each 27.0000 2 2

Location	Loc Qty	Loc Code
LG002	27	
64564	27	

BE 12/02/29
*B78015 * 2*

D2680-041
Nut Plate
Manufactured No 210 Each 19.0000 1 1

Location	Loc Qty	Loc Code
ST020	19	
55366	17	
70088	2	

(1) JB

CR3212-4-03
Cherry Rivet
Purchased No 210 Each 1,138.000 2 2

Location	Loc Qty	Loc Code
FP-B	2	
110139	2	
ST311	1136	
114859	1136	

(2) 2
B 12/03/04

CCR264SS3-3
Cherry Rivet
Purchased No 210 Each 435.0000 2 2

Location	Loc Qty	Loc Code
FP-B	2	
113973	2	
ST311	433	
117086	23	
117849	410	

(2) 2
B 12/03/04

Tuesday, September 20, 2011 10:26:30 AM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:26:30 AM

Page 4

Work Order ID: 73991

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

88.0000

1

1



Aft Cap



1379500 (x1) JH 12/03/07

Location

Loc Qty

Loc Code

FP004

44

68280

44

FP006

5

62678

5

FP-4

35

70945

1

71070

34

fp5

4

71038

4

D2651-1

Manufactured No

270

Each

289.0000

18

18



Plug



1378124 (x18) JH 12/03/07

Location

Loc Qty

Loc Code

fpa

109

69018

109

FP-A

180

57869

1

66445

10

67760

36

70691

100

70839

2

71037

31

AN960JD416

NAS1149D0463J

Purchased

No

270

Each

0.0000

1

1



Washer



11118384 (x1) JH 12/03/07

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:26:30 AM

Page 5

Work Order ID: 73991

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-3 Manufactured No

270

Each

799.0000

18

18



O-Ring



B73828 (x18) MU n103107

Location

Loc Qty

Loc Code

FP-A

799

61962

12

66956

282

73489

505

MS27039-1-08

Purchased

No

270

Each

1,296.000

46

46



Screw



M119075 (x46) MU n103107

Location

Loc Qty

Loc Code

ST291

1296

115108

96

117423

300

118378

400

118910

500

ALS4-1032-130

Purchased

No

270

Each

502.0000

44

44



Insert



M120671 (x44) MU n103107

Location

Loc Qty

Loc Code

ST281

370

118386

370

ST282

132

117717

46

118237

48

118312

38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:26:30 AM

Work Order ID: 73991

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

270

Each

29.0000

1

1



Screw



1119075(x) 11 11/03/07

Location

Loc Qty

Loc Code

FP-A

8

115460

8

ST292

21

115460

21

AN960JD10L

NAS1149D0332J

Purchased

No

270

Each

0.0000

46

46



Washer



1119042 => 18x 11120644 => 28x 11 12/03/07

D3537-1

Manufactured

No

270

Each

70.0000

4

4



Wearpad



B78592(x) 41 11 11/03/07

Location

Loc Qty

Loc Code

FP001

60

72124

60

FP016

3

68944

0

70687

3

FP017

7

69817

5

70686

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:26:31 AM

Page 7

Work Order ID: 73991

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Manufactured No

270

Each

21.0000

1

1



Wearpad



B74560 (x1) M 11/03/07

Location

Loc Qty

Loc Code

FP

4

70481

4

FP017

17

35697

1

72144

11

72686

5

D3535-13

Manufactured No

270

Each

9.0000

1

1



Wearshoe



B74616 (x1) M 11/03/07

Location

Loc Qty

Loc Code

FP018

9

72786

9

D3536-13

Manufactured No

270

Each

16.0000

1

1



Gasket



1378964 (x1) M 12/03/07

Location

Loc Qty

Loc Code

FP011

16

70463

3

72880

13

D3535-21

Manufactured No

270

Each

15.0000

1

1



Wearshoe



M 12/03/07

Location

Loc Qty

Loc Code

FP018

15

65788

1

70380

8

70461

6

xl

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:26:31 AM

Page 8

Work Order ID: 73991

Parent Item: D206-642-241



Parent Item Name: Replacement Skidtube

Start Date: 9/20/2011



Required Date: 10/11/2011

Start Qty: 1.00



Required Qty: 1.00

D3536-21	Manufactured	No	270	Each	14.0000	1	1
							<u>12/03/07</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	14	
61684	2	
<u>70464</u>	12	

D3535-33	Manufactured	No	270	Each	18.0000	1	1
							<u>12/03/07</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP019	18	
70383	8	
<u>70462</u>	10	

D3536-33	Manufactured	No	270	Each	26.0000	1	1
							<u>12/03/07</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012	26	
70382	10	
<u>70465</u>	16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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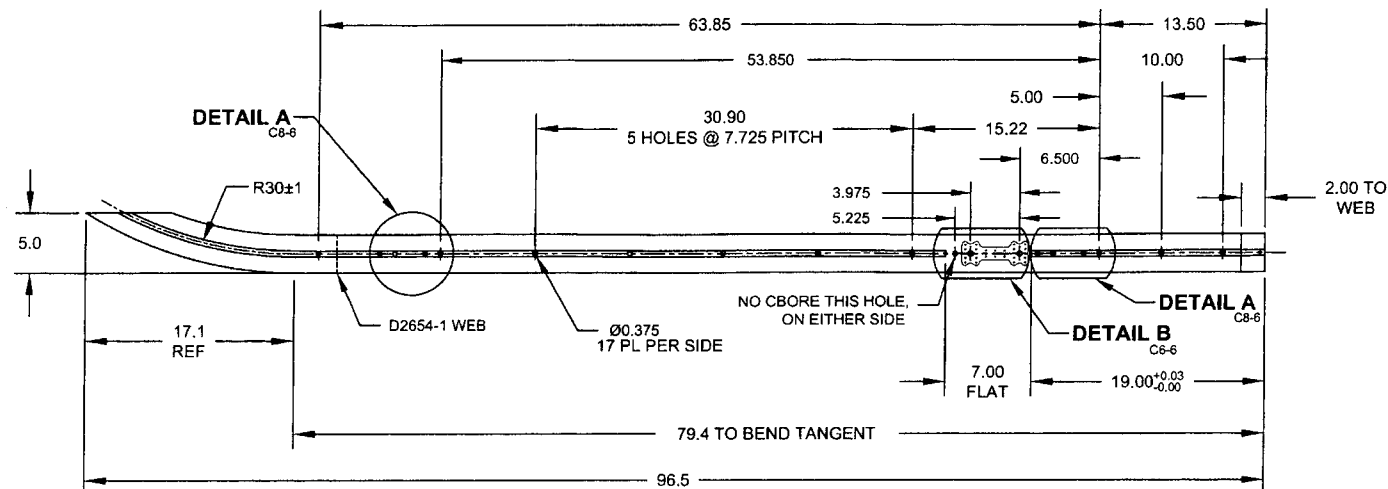
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

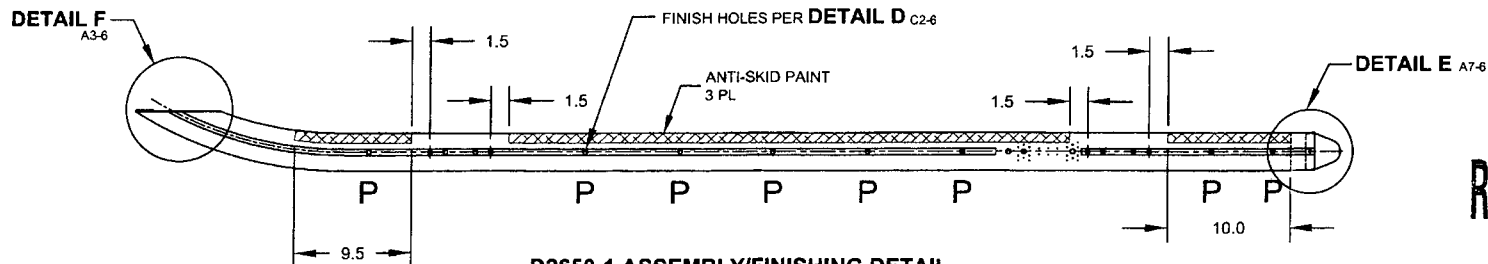
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

#78991

RELEASED
68-0922/114

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

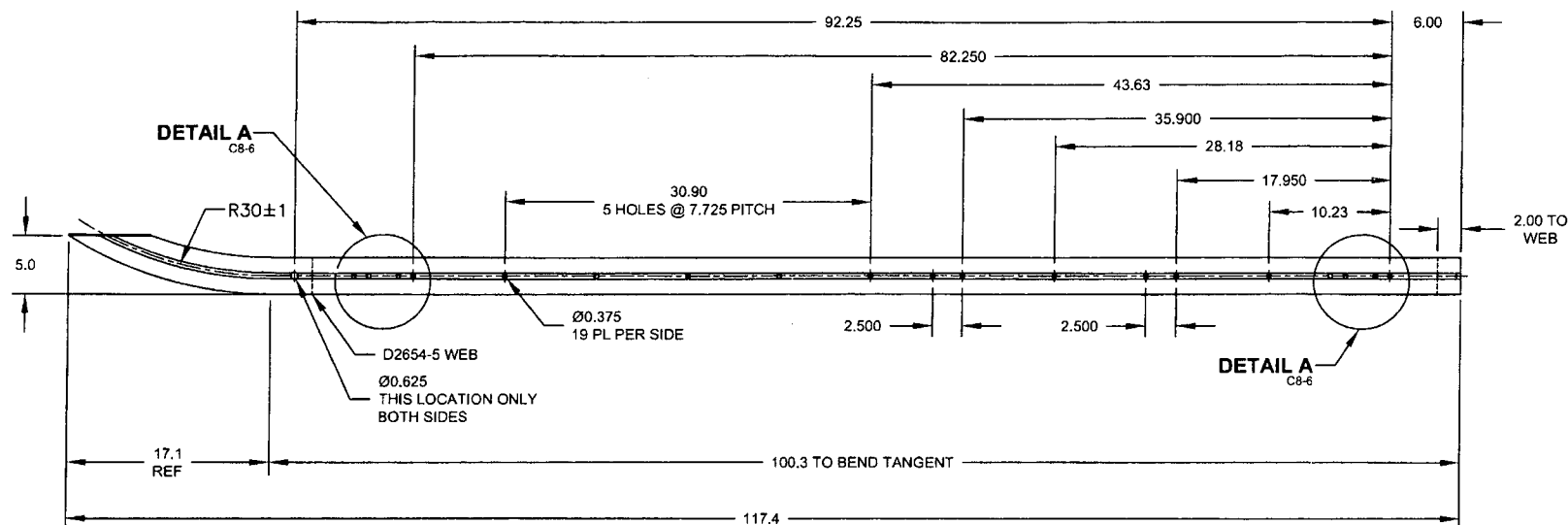
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

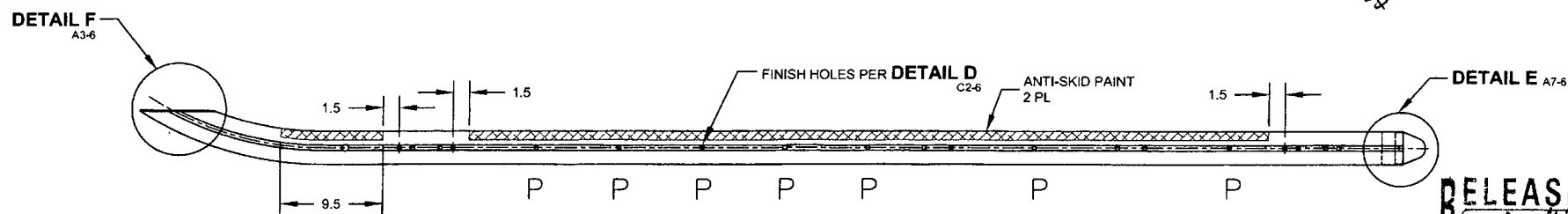
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign. & Date			





NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
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RELEASED
08.09.22.11

73991

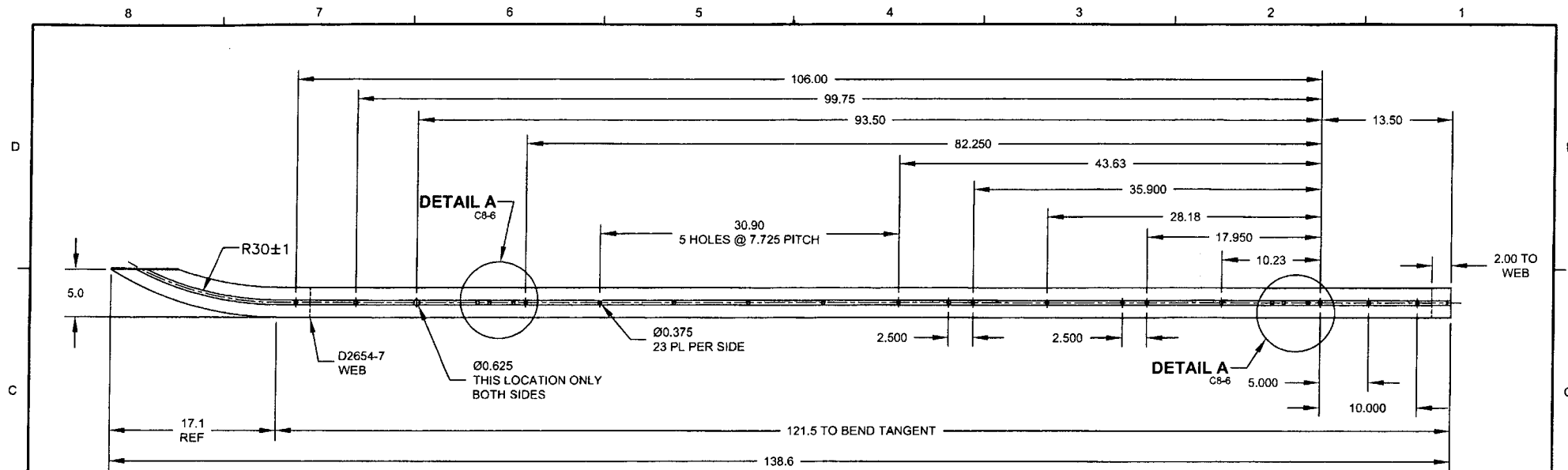
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

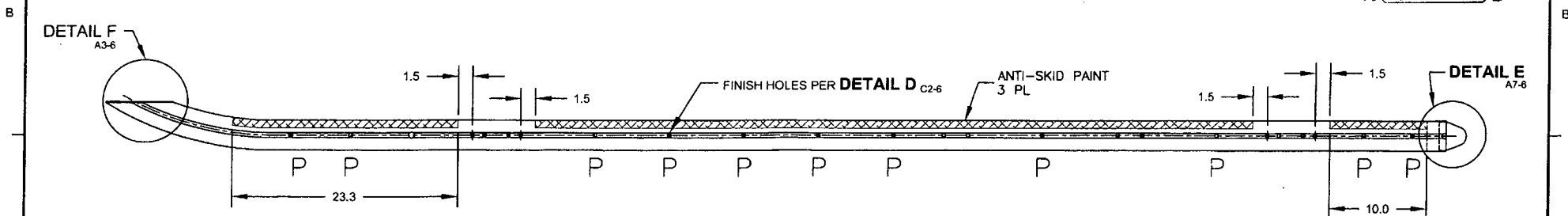
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-7 BENDING/DRILL DETAIL

#73991
RELEASED
 08-07-22



D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
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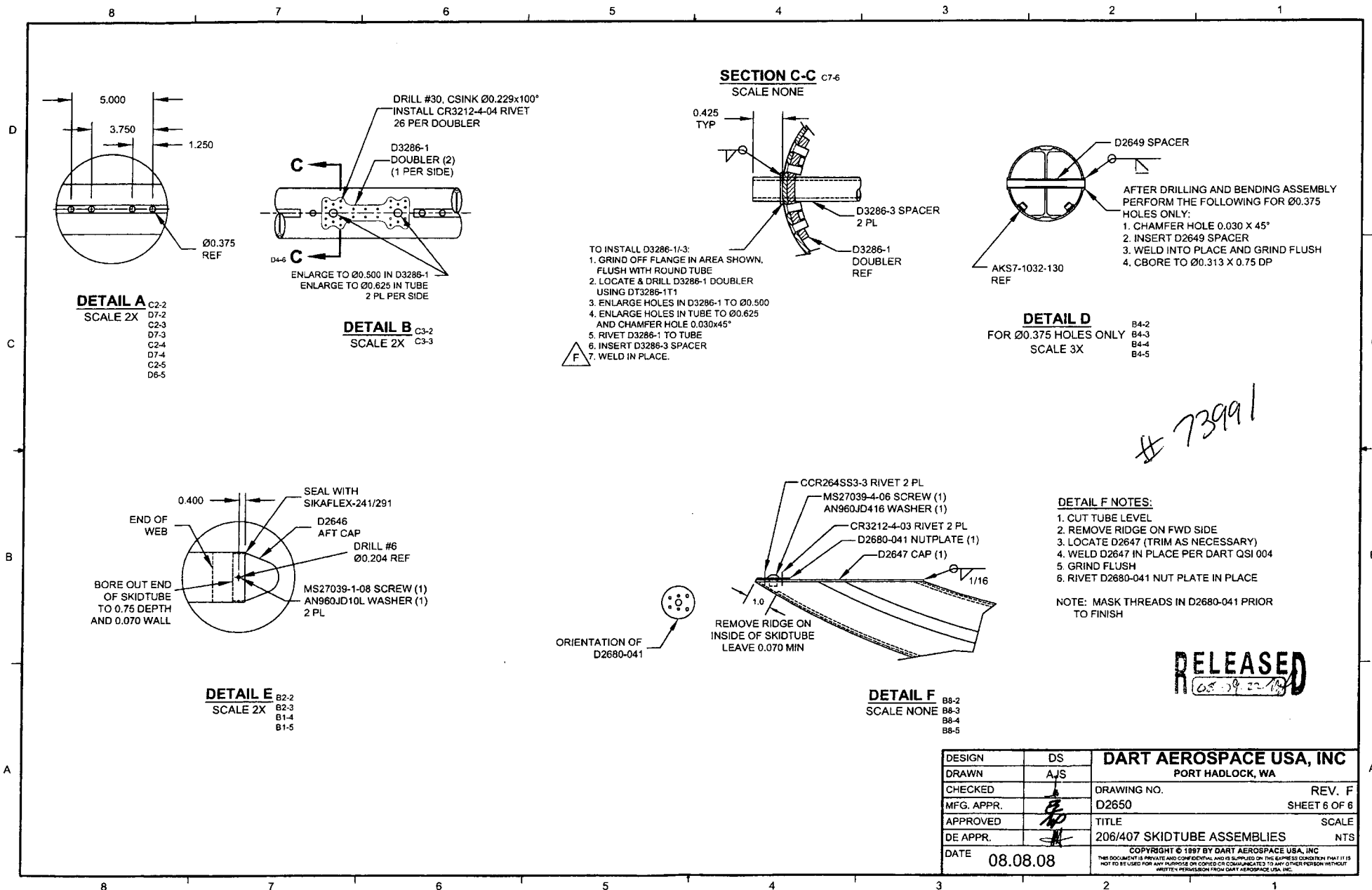
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 283

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 79243
Part number: A206-642-151
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Nuvell Date of Test Coupon 12.02.22

Welder Barclay Elliott Date of Test Coupon 12.02.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld